

Date: Wednesday, 13/05/2009 1:46:35 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 47946
 Estimate Number : 12455
 P.O. Number :
 This Issue : 13/05/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : LARGE FAB ASSY
 Previous Run : 45187
 Written By :
 Checked & Approved By : Julie Dawson 05.13
 Comment : Est Rev:B 05.10.14 Modified step 10 KJ/EC
 Est Rev:B 06.07.19 D2946 @ rev.b EC

Drawing Name : AFT MAINTENACE STEP
 Part Number : D350591133
 Drawing Number : D2946 REV B
 Project Number : N/A
 Drawing Revision : REV. B
 Material :
 Due Date : 26/05/2009

Qty: 4 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-133 CHG002

2.0 D2622120C Step Extrusion



Comment: Qty.: 0.5250 Each(s)/Unit Total : 2.1000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D2622-120C Extrusion 346910

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 62.06" long as per Dwg D2946

2-Deburr

Ensure that 57.09" minimum extrusion is kept and identify to be used for D350-591-215/-216.

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5.0 D2734 Step End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Seq. #:

Machine Or Operation:

Description :

2 D2734

End Plate 343535

Ph 09.06.22 6

6.0

D2944

Step Mounting Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2944 Support 336407

Ph 09.06.22 6

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Deburr and Bevel ends for welding

2-Weld (1) End Cap and (2) Lugs using Jig DT8440 as per Dwg D2946

A/R Aluminum Rod M110130
M110972

3-Grind End Cap welds flush

Ph 09.06.23 6

Ph 09.06.23 6

Ph 09.06.23 6

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Ph 09.06.23 6

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ph 09.06.23 6

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Ph 09.06.23 6

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAD 09-06-23 6

W/O:		WORK ORDER CHANGES						
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Job Number: 47946

Part Number: D350591133

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Remove alodine prior to welding. Weld end cap as per Dwg D2946. Grind end cap weld flush.

A/R AL ROD BATCH: M110130

29.06.23 6

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

RF 09-06-24 6

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/06/24 (x6)

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch Up Chemical conversion

9/6

09-06-24

(x6)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M111472 x pressure wash

09-06-24 (x6)

START TIME:

10:00AM

OVEN TEMPERATURE:

320°C

FINISH TIME:

10:30AM

9/6

09-06-24 (x6)

(x)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2946 and QSI 005 4.4

M111013

9/6/24 LMD

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

9/6/24

SV 4x

W/O:		WORK ORDER CHANGES						
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Seq. #: Machine Or Operation: Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

20.0

D22301

Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)
Mounting Lug
Batch: 747911

Rev F

9/6/24

510

21.0

D22303

Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)
Mounting Lug
Batch: 47965

Rev F

9/6/24

54

22.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2606 f(s)/Unit Total : 5.0425 f(s)
Abrasion Strip 7.20" long x2
Batch: 546543

9/6/24

58

23.0

D2945

Step Mounting Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Step Mounting Plate
Batch: 245264

9/6/24

51

24.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Bolt
Batch: 1110155

9/6/24

54

25.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)
Bolt
Batch: 11106605

9/6/24

54

W/O:		WORK ORDER CHANGES						
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Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN414A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Bolt

Batch: M110372

9/6/24

54

27.0

AN960JD416

Washer



Comment: Qty.: 14.0000 Each(s)/Unit Total : 56.0000 Each(s)

Washer

Batch: M111279

9/6/24

50

28.0

MS21042L4

Nut



Comment: Qty.: 14.0000 Each(s)/Unit Total : 56.0000 Each(s)

Nut

Batch: M110507

9/6/24

34

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8 08/06/24 (4)

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-213

Location: 80

PPP Rev: 2

9/6/24

54

31.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/25 (4)

Job Completion



u 09.06.24

W/O:		WORK ORDER CHANGES						
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D2946 STEP ASSEMBLY PARTS LIST